

Date: Wednesday, 4/5/2006 3:29:59 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET ASSEMBLY	
Job Number	: 26564		Part Number	: D2803042	
Estimate Number	: 11030		Drawing Number	: D2803 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 4/5/2006		S.O. No.	: N/A	
Prsht Rev.	: NC		Type	: PURCHASED PARTS	
First Issue	: N/A		Material	: N/A	
Previous Run	: 25918		Due Date	: 4/27/2006	
Written By	: See comment below		Qty:	10	Um: Each
Checked & Approved By	: GJ 06.04.06				
Comment	: Est F 05.03.30 MS21043-3 was MS21042L3		KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D28032	STA 84 Bracket	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) STA 84 BRACKET Pick: Qty Part Number Description Batch 1 D2803-2 Bracket <u>B26588</u> /			
2.0	D28052	Stop	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) STOP Pick: Qty Part Number Description Batch 1 D2805-2 Stop <u>B25932</u> /			
3.0	D2809	Bushing	

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Bushing Pick: Qty Part Number Description Batch 1 D2809 Bushing <u>B25959</u>
--

Press D2805-2 into arm as per Dwg D2803

5/05/02 05:02 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/5/2006 3:29:59 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 26564

Part Number: D2803042

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0

QEZ

ALS

Z

INSPECT PARTS AS THEY COME OFF MACHINE



PD

Comment: INSPECT PARTS AS THEY COME OFF MACHINE Inspect work

5.0

POWDER COATING

POWDER COATING



(10)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL ocaloslo4

(10)

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



10

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



(10)

Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2803

SAP 06:05:06

(10)

8.0 AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C16A	Bolt	M17944

9.0 MS210433

Nut



(10)

Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21043-3	Nut	M100218

10.0 NAS1515H3

Washer



(10)

Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H3	Washer	M19633

A/R LPS-3

Corrosion Spray

M17045

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803

SAP 06:05:06 (10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06/05/04	4	QC S req'd for inspection of press fit. permanent change.				<i>[Signature]</i>	<i>[Signature]</i> 06/05/04	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/05/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/5/2006 3:30:00 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 26564

Part Number: D2803042

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per Dwg D2803.

SAP 06/05/06 18

12.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: ST158

6/05/11

10

14.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

DP 06/05/11

Job Completion



U 06/05/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

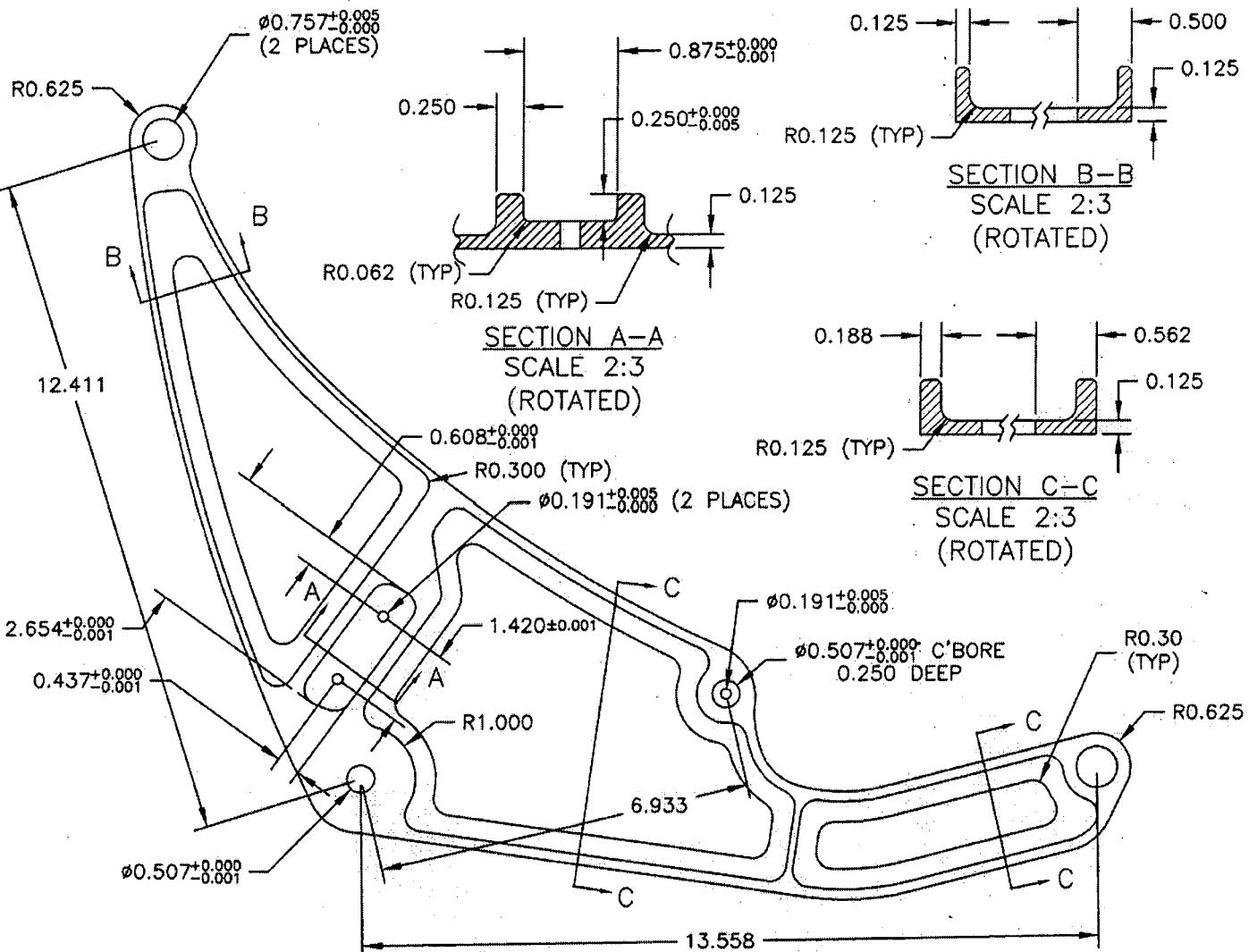
## **DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B	SHEET 1 OF 2
DATE 04.11.22	TITLE STA 84 BRACKET		SCALE 1:3	

RELEASED

05.03.11 - //

A 00.11.07 NEW ISSUE  
B 04.11.22 ADD CUTOUTS & -043/-044



D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)

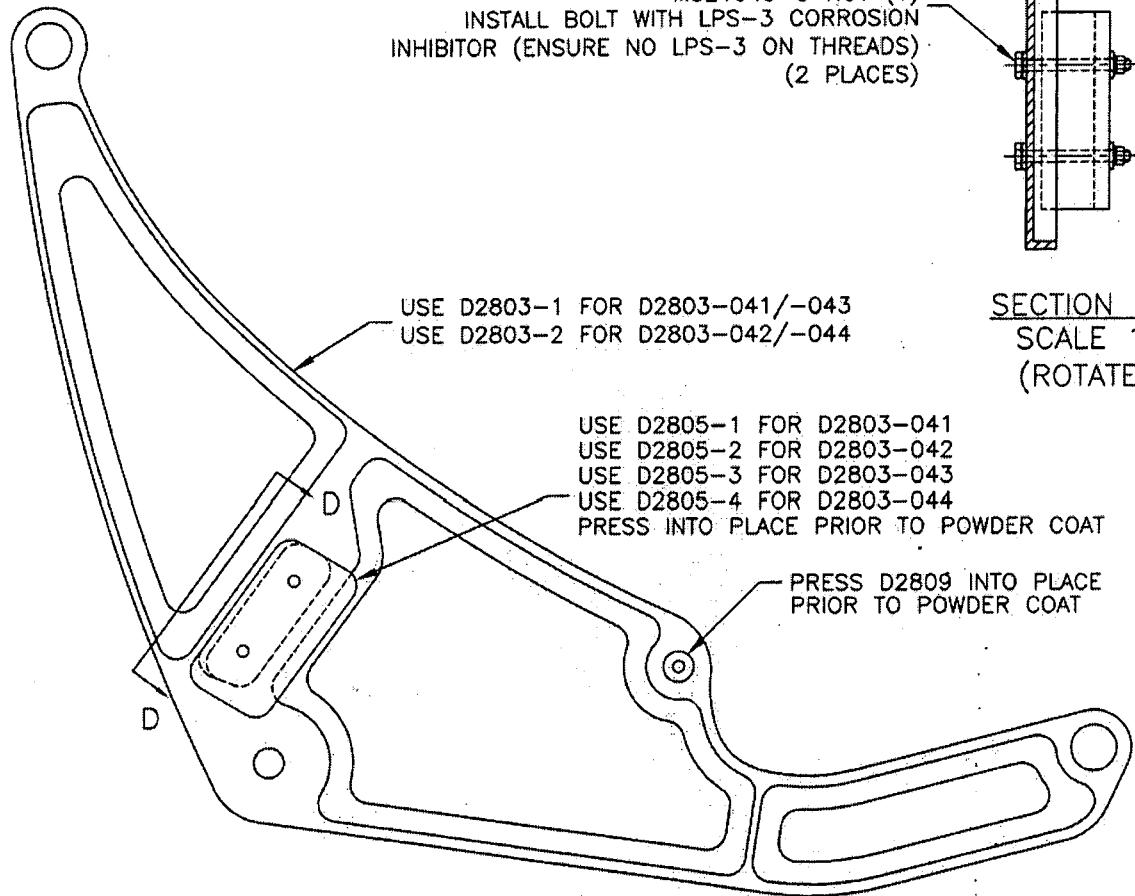
- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER  
NO. 26564

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**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



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05-03-11 *[Signature]* WITHOUT NOTICE  
WORK ORDER  
NO. *26564*

D2803-041/-043 BRACKET ASS'Y (SHOWN)

D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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